Qty:

50 Um:

: HINGE BRACKET PLATE

: D2179

: 11/9/2007

: N/A

: B

- D2179 REV. B

Tuesday, 10/30/2007 2:48:30 PM

_User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material **Due Date**

Drawing Number

Project Number

Drawing Revision

Each

Customer

: CU-DAR001 Dart Helicopters Services

Estimate Number

Job Number

: 35432 : 10199

P.O. Number

: 10/30/2007

This Issue Prsht Rev.

First Issue

Previous Run

: NC : 11

Type

S.O. No. :

: SMALL /MED FAB

: 30630

Written By Checked & Approved By

Comment

90.07.17 New Issue EC : Est Á

-Est Rev:B Now on Waterjet 07-02-05 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M5052H32S040

Comment: Qty.:

0.0096 sf(s)/Unit

Total:

0.4778 sf(s)

Material: 5052-H32 (or 6061-T6) 0.040" thick

(M5052H32S.040)

5052-H32 .040 Sheet

WATER JET 2.0

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2179

Dwg Rev: B 13 07 -11 -1

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

図の



07-11-01

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

HAND FINISHING 5.0

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Dart Aerospace Ltd

| W/O: | · | | WC | RK ORDER CHANG | FS | | | <u></u> | |
|---------|------|-------------------|----------------------|------------------------------|----------------|------------|--------------|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | 1 | |
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| | | | | | | · | | : | |
| | | | | | | | | - - | |
| Part No | • | PAR #: | Fault Cateç | gory: | NCR: Yes | No DQA | \: | Date: | |
| | | | | | QA: N | I/C Closed | l: | Date: | |
| NCR: | | | WORK ORDE | ER NON-CONFORMA | NCE (NCF | ₹) | | | |
| DATE | STEP | Description of NC | | Corrective Action Section B | | | Verification | Approval | Approval |
| | 0.2. | Section A | Initial Chief Eng | Action Description Chief Eng | Sign 8 Date | Section | n C | Chief Eng | QC Inspector |
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NOTE: Date & initial all entries

Date: User: Tuesday, 10/30/2007 2:48:30 PM Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HINGE BRACKET PLATE Part Number: D2179 Job Number: 35432 Job Number: Description: Seq. #: **Machine Or Operation:** POWDER COATING POWDER COATING M105 914 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMIC 7.0 Comment: INSPECT POWDER COAT 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ FINAL INSPECTION/W/O RELEASE 9.0 QC21 M.IL OT

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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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| W/O: | | WORK ORDER CHANGES | | | | | | | | | |
| DATE STEP | | PROCEDURE CHANGE | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
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| Part No | : | PAR #: | Fault Category: | NCR: Yes | No DQ | A: | Date: | | | | |
| | | | | QA: | N/C Close | d: | _ Date: _ | ···· | | | |
| NCR: | | WO | RK ORDER NON-CON | IFORMANCE (NO | R) | | | | | | |
| | | D | Corrective Action | n Section B | | | | | | | |

| WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|----------------------------------|---------------------------------------|------------------------|--|---|--|--|---|--|
| | EP Description of NC Section A | | Corrective Action Section B | | | | | |
| STEP | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | Approval QC Inspector | |
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| | STEP | STEP Description of NC | STEP Description of NC Section A Initial | STEP Description of NC Section A Initial Action Description | STEP Description of NC Section A Initial Action Description Sign & | STEP Description of NC Section A Initial Action Description Sign & Section C | STEP Description of NC Section A Proval Initial Action Description Sign & Section C Chief English | |

NOTE: Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 35+32 |
|----------------------------------|--------------|-------------|
| Description: Hinge Bracket Plate | Part Number: | D2179 |
| Inspection Dwg: D2179 Rev: B | | Page 1 of 1 |

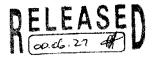
| FIRST ARTICLE INSPECTION CHECKLIST | | | | | | | | | |
|------------------------------------|---------------|---------------------|-------------|--------|----------------------|------------|---|--|--|
| X First Article Prototype | | | | | | | | | |
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | | mments | | |
| 0.350 | +/-0.010 | 350 | * | | | | | | |
| 1.170 | +/-0.010 | 1.170 | ¥ | | | | | | |
| 1.520 | +/-0.010 | 1.526 | 1 00 | | | | | | |
| 0.340 | +/-0.010 | ,340 | 20 | | | | | | |
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| Measured by: | B | Audited by: | مل | | Prototype A | Approval: | N/A | | |
| Date: | 1-01-10 | Date: | 7/11 | 05 | | Date: | N/A | | |
| Rev Date | Change | | | | | Revised by | Approv <i>e</i> d | | |
| A 04.10.05 | New Issue | | | | | KJ/JLM | - 411 | | |

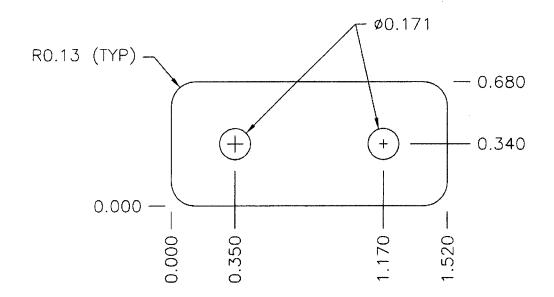
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|---|-------|---------|----------------|---|-----------|
| | CHECK | KED, | APPROYED | DRAWING NO. | REV. B |
| | | 4 | # | D2179 SHE | ET 1 OF 1 |
| 1 | DATE | | | TITLE | SCALE |
| | 00.0 | 06.20 | | HINGE BRACKET PLATE | 2:1 |
| | Α | | 95.03.17 | NEW ISSUE | |
| | В | | 00.06.20 | DWG No. D2179 WAS D2399 | |





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WORK ORDER

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11)

OR 2024-T3 (QQ-A-250/4) 0.040 THICK

FINISH: CHEMICAL CONVENSION COAT PER DART QSI 005 4.1

POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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